

WHAT IS CLAIMED IS:

1. A charging roller for a contact charging assembly, comprising a conductive substrate, an elastic layer which covers the periphery of the conductive substrate, and a seamless tube externally so fitted as to cover the periphery of the elastic layer,

wherein said seamless tube constitutes a surface layer of the charging roller, and

10 wherein said charging roller has a surface of 3.0 μm or less in ten-point average roughness R_z jis 94, and 0.10 mm or less in roughness curve average length R_{Sm} .

15 2. The charging roller according to claim 1, wherein said seamless tube comprises a high-impact polystyrene HIPS.

3. The charging roller according to claim 1, wherein said seamless tube comprises:
(A) a thermoplastic styrene elastomer, and
(B) a high-impact polystyrene HIPS;
and a proportion of the component (A) to the component (A) is $(A)/(B) = 80/20$ to $40/60$ in weight ratio.

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4. The charging roller according to claim 1, wherein said seamless tube comprises a multi-layer

structure having a plurality of layers.

5 5. A process cartridge comprising an
electrophotographic photosensitive member and the
charging roller according to claim 1 which are
integrally supported together, and being detachably
mountable on a main body of an electrophotographic
apparatus.

10 6. An electrophotographic apparatus comprising an
electrophotographic photosensitive member and the
charging roller according to claim 1.